

Date: Wednesday, 3/28/2007 12:40:12 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTER AFT SADDLE
Job Number	: 31530		
Estimate Number	: 11080		
P.O. Number	: <i>N/A</i>	Part Number	: D5955
This Issue	: 3/28/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D5955 REV B
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 28082	Drawing Revision	: B
		Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 4/15/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	6 Um: Each
Comment	Est Rev:E Re-Format 05-11-29 JLM Est Rev:F ecn826 06.12.06 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	D6101013	Saddle billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

D6101-013 (7075-T7351)

Size 2.50" x 10.10" X 8.25" (Grain along 10.10")

Batch: *B25356*

J.L 07/04/01

(6)

2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
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Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5955, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr & Tumble

J.L 07/04/02

(6)

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

J.L 07/04/02

(6)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

mk 07/04/02

(6)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1







M.R

07/04/03

(6x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.02	3.0	ONE PART, CHAMFER ON X-BOLT SPACER HOLE STANDOFF IS 0.125 x 45° INSTEAD OF 0.040 x 45°. 		ACCEPTABLE DEVIATION	J.L. 07/04/02 	 07/04/02	 07.04.02	 07/04/02

NOTE: Date & initial all entries

Date: Wednesday, 3/28/2007 12:40:12 PM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTER AFT SADDLE

Job Number: 31530

Part Number: D5955

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

POWDER COATING

POWDER COATING



M103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL

07/04/03 (6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

EP 07/04/04 @

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/04/04 @

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

EP 07/04/05

Job Completion



U 04.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31530
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955	Rev: B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		6.999	6.998	6.998	6.999		
E	5.745	5.755		5.750	5.750	5.750	5.749		
F	4.745	4.755		4.750	4.749	4.750	4.750		
G	0.313	0.318		.316	.316	.316	.316		
H	1.522	1.532		1.527	1.527	1.528	1.527		
I	3.048	3.058		3.053	3.054	3.053	3.053		
J	4.575	4.585		4.579	4.580	4.579	4.579		
K	0.313	0.318		.316	.316	.316	.316		
L	0.495	0.505		.501	.502	.501	.500		
M	0.490	0.510		.500	.502	.500	.502		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		7.998	7.998	7.999	7.998		
P	2.240	2.260		2.252	2.252	2.253	2.253		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.761	.761	.761	.761		
S	0.490	0.510		.498	.497	.500	.500		
T	1.625	1.645		1.629	1.630	1.629	1.630		
U	2.000	2.020		2.001	2.001	2.001	2.002		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	07/04/01

Audited by:	ML
Date:	07/04/02

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD		Work Order:	31530
Description: Outer Aft Saddle		Part Number:	D5955
Inspection Dwg: D5955		Rev: B	Page 1 of 1

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B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.251	2.250				
D	6.995	7.005		6.998	6.999				
E	5.745	5.755		5.750	5.749				
F	4.745	4.755		4.751	4.750				
G	0.313	0.318		.316	.316				
H	1.522	1.532		1.527	1.527				
I	3.048	3.058		3.053	3.053				
J	4.575	4.585		4.579	4.580				
K	0.313	0.318		.316	.316				
L	0.495	0.505		.501	.501				
M	0.490	0.510		.500	.502				
N	1.865	1.885		1.875	1.875				
O	7.990	8.010		7.998	7.998				
P	2.240	2.260		2.252	2.252				
Q	0.307	0.312		.310	.310				
R	0.760	0.765		.761	.761				
S	0.490	0.510		.502	.500				
T	1.625	1.645		1.632	1.632				
U	2.000	2.020		2.004	2.003				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

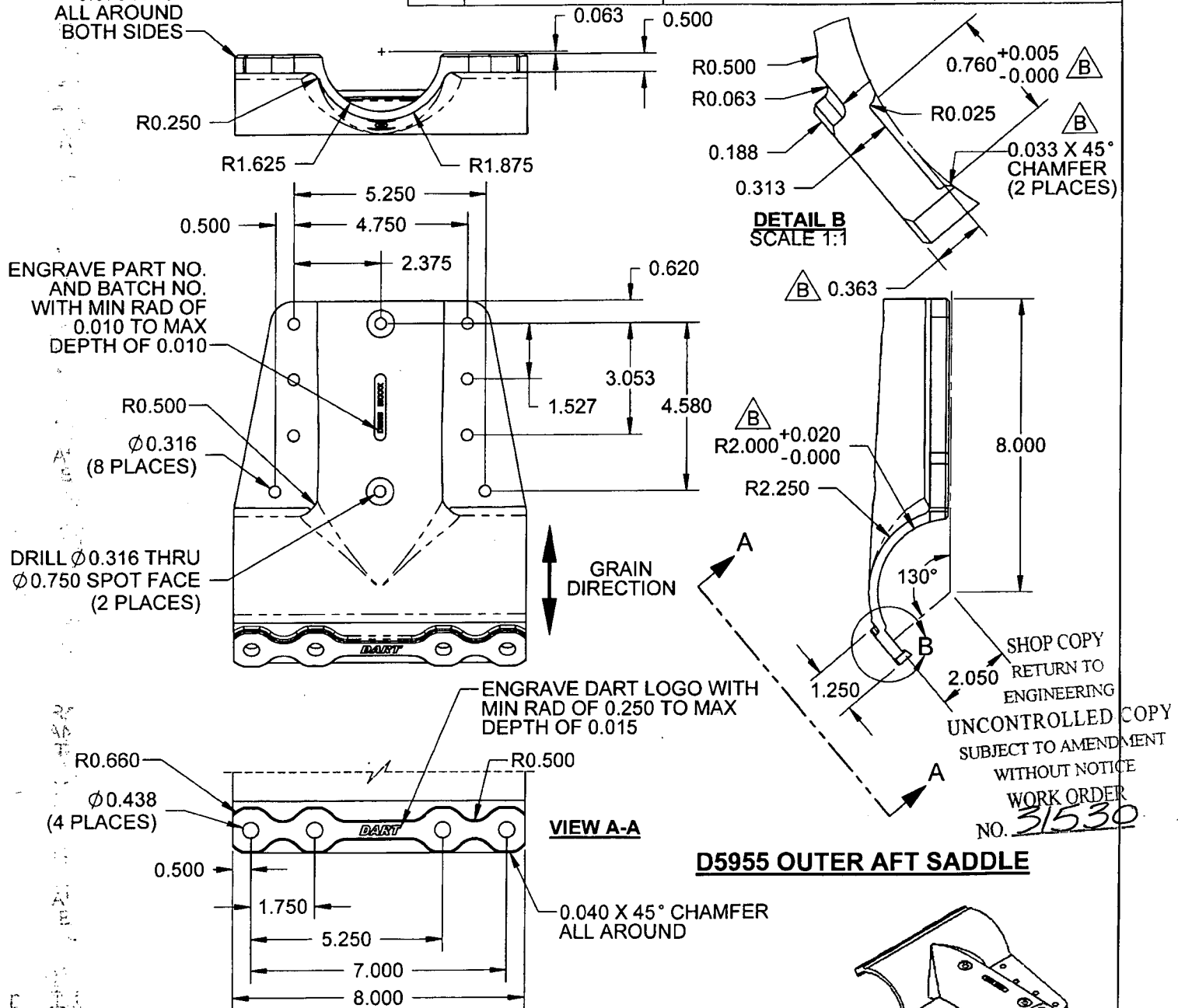
Measured by:	J.L
Date:	07/04/02

Audited by:	Jmk
Date:	07/04/02

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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED LE	APPROVED H	DRAWING NO. D5955
DATE 06.11.07	TITLE OUTER AFT SADDLE	REV. B SHEET 1 OF 1 SCALE 1:4
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE
REV B	DATE 06.11.07	DESCRIPTION INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-013 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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